



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6405G02131-3G
Job Sheet 171012



001064

Part No: RBW6405G02131-3G

Job Qty: 2 pcs

Part Name: Tail Rotor Blade Damper Attachment Bushing Removal



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6405G02131-3G Rev D IPP Rev.A 17.08.29 New issue DP Verify DD IPP Rev B 17.11.14 Rev Rev B DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		1/31/18	0.00	0.00	Start Up Small Fab-4		MCL
110	Small Fab	2 pcs		1/31/18	0.00	0.00	Small Fab-8		MCL DAS
120	QC	2 pcs		1/31/18	0.00	0.00	QC5		38
130	Packaging	2 pcs		1/31/18	0.00	0.00	Packaging3-1 GA		FEB 23 2018
140	QC	2 pcs		1/31/18	0.00	0.00	QC21		

DAS
21
9-60

FEB 26 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
94191A150	Hex Nut 1/4-28 UNF	2 pcs (1 ea)	90-Start up Operation	
95229A420	Flat Washer	2 pcs (1 ea)	90-Start up Operation	
RBW6405G02131-3G-1	Bolt	2 Ea (1 ea)	90-Start up Operation	
RBW6405G02131-3G-3	Bell	2 Ea (1 ea)	90-Start up Operation	
RBW6405G02131-3G-5	Quarter Bell	4 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	94191A150 5010649	2	24	0
	95229A420 5016491	2	98	0
	RBW6405G02131-3G-1	2	0	0
	RBW6405G02131-3G-3	2	3	0
	RBW6405G02131-3G-5	4	1	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



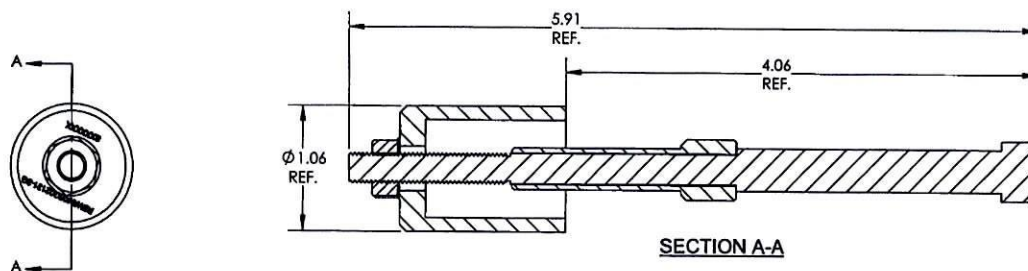
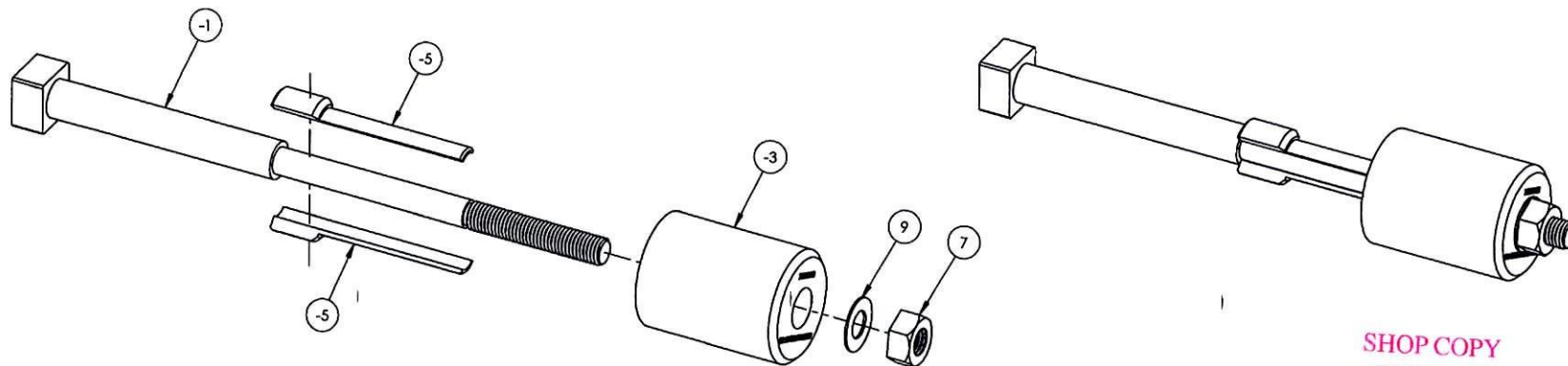
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 15%;">Skid-tube</td> <td style="width: 15%;">Cross tube</td> <td style="width: 15%;">Water Jet</td> <td style="width: 15%;">Engineering</td> </tr> <tr> <td>Machining</td> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td>Thermoforming</td> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td>Large Fab</td> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table>				Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
Skid-tube	Cross tube	Water Jet	Engineering																				
Machining	Small Fab	Prod. Eng. Coord.	Quality																				
Thermoforming	Finishing	Rec/Store/Packaging	Other																				
Large Fab	Composite	Supplier																					
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Description / Work Order Deviation				Disposition																			
Dart Aerospace Ltd. 1270 Aberdeen Street CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S044141 Part: RBW6405G02131-3G Job No: 171012 Serial No/Batch: S044141 Revision: RBW6405G02131-3G Inspector: Date: 02/21/18																							
Environr D: Equip Hanc.		Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified		Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center		Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence																	

ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-1	1	RBW6405G02131-3G-1	BOLT	2	1	CH'D TITLEBLOCK WAS RED BARN IS DART. -1 CH'D DIM WAS 4X.03 X 45" IS 4X R.34. -5 ADDED DIM (.330), CH'D DIM WAS 1.430 IS 1.45.	14-0205	10/31/2014	DJN	JAG
-3	1	RBW6405G02131-3G-3	BELL	3						
-5	2	RBW6405G02131-3G-5	QUARTER BELL	4	2	-1 AND -5 CH'D MATERIAL CALL OUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -5 ADDED PART MARK FOR PAIRS NOTE.	15-0294	9/10/2015	RJC	JAG
7	1	McMaster#94191A150	HEX NUT 1/4"-28 UNF GRADE 8	-						
9	1	McMaster#95228A420	FLAT WASHER 1/4"	-						
					3	-1 CH'D MAT'L WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. -3 DELETED DIMS (.220), (2X .118). CH'D DIM WAS 1.12 IS 1.20. -5 CH'D MAT'L WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. DELETED DIM 42".	17-0161	6/23/2017	DPD	JAG
					D	-1 & -5 MATERIAL 4140-4142 CHANGED FOR 4140-4142 Q&T Rc ADDED, TEMPLATE UPDATED	17-717	17.10.19	VM	WM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171012 MJS
18-01-25

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) REF AGUSTA T/N: 3G6405G02131

RBW6405G02131-3G TAIL ROTOR BLADE DAMPER ATTACHMENT BUSHING REMOVAL

DART AEROSPACE Hawkebury, Ontario, Canada	
TITLE TAIL ROTOR BLADE DAMPER ATTACHMENT BUSHING REMOVAL	
DWG NO. RBW6405G02131-3G	REV D
DESIGN BY: VM 10/19/2017	JOK ± .005 FRACTIONS ± 1/8
DRAWN BY: VM 10/30/2017	3/4 ± .01 ANGLES ± 1°
CHECKED: SAC 10/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
MFG. APPR: DD 10/31/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: WWM 11/02/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
DATE: 10/30/2017	
SCALE: NTS	WEIGHT: N/A
SHEET 1 OF 4	
COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	